

Date: Monday, 6/26/2006 7:12:34 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HI-SKI STEP LEG
Job Number	: 27683		
Estimate Number	: 11832		
P.O. Number	: NIA	Part Number	: D2498
This Issue	: 6/26/2006 S.O. No. : NIA	Drawing Number	: D2498 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: NIA	Material	: NIA
Written By	: <u>SEE COMMENT, BEKW</u>	Due Date	: 7/3/2006
Checked & Approved By	: <u>W</u>	Qty:	12 Um: Each
Comment	: Est. A02.06.06 New Issue NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B1000X04000	6061-T6 Bar 1.0" x 4.0"
-----	--------------------	-------------------------



Comment: Qty.: 1.8445 f(s)/Unit Total: 22.1344 f(s)

6061-T6 Bar 1.0" x 4.0"

6061-T6 1.00" Thick

Batch M12315

Trk 06/06/23

12

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 8.500" x 4.000"

Trk 06/06/23

12

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2499

Deburr

Trk 06/06/24

12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Trk 06/06/24

12

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

EP 06/06/26 + 12

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.m 06-06-27

(12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06/06/27	6	Abolish before powder coat. Permanent change.						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/26/2006 7:12:34 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-SKI STEP LEG

Job Number: 27683

Part Number: D2498

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M/ 8/8/27*

*12*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57179*

*6/6/27*

*(12)*

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*8/6/27*

Job Completion



*6/8/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

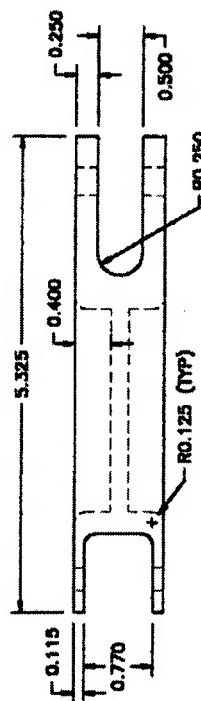
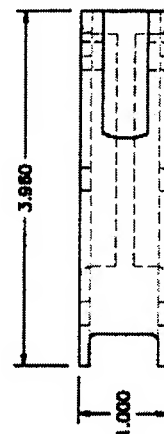
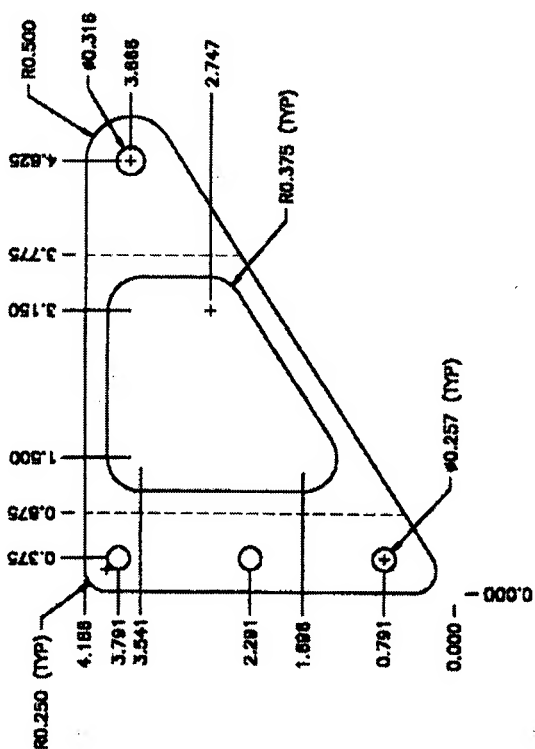
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2498	SHEET 1 OF 1
DATE		TITLE	SCALE
95:11:09		MOUNT	1:2



**MATERIAL: 6061-T6 ALUMINUM**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order: 27683
Description: # MOUNT		Part Number: D2498
Inspection Dwg: D2498, Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.960	$\pm 0.010$	3.957	—			
1.000	$\pm 0.010$	1.005	—			
0.250	$\pm 0.010$	0.253	—			
0.500	$\pm 0.010$	0.499	—			
0.400	$\pm 0.010$	0.403	—			
R0.125	$\pm 0.010$	R0.125	—			
0.720	$\pm 0.010$	0.760	—			
0.115	$\pm 0.010$	0.123	—			
5.325	$\pm 0.010$	5.325	—			
<del>0.775</del>	<del><math>\pm 0.010</math></del>					
<del>3.775</del>	<del><math>\pm 0.010</math></del>					
<del>3.775</del>	<del><math>\pm 0.010</math></del>					
<del>4.825</del>	<del><math>\pm 0.010</math></del>					
0.875	$\pm 0.010$	0.878	—			
3.775	$\pm 0.010$	3.780	—			
4.825	$\pm 0.010$	4.825	—			
8.316	$\pm 0.005$	8.316	—			
80.257	$\pm 0.005$	80.258	—			

Measured by: <i>mil</i>
Date: 06/06/26

Audited by: <i>En</i>
Date: 06/06/26

Prototype Approval: <i>N/A</i>
Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	